

Work Order ID 79199

79199

Page 1

January-23-12 1:58:14 PM

Item ID: D2661-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, LH Fwd Aft Out 206
 Start Date: 23/01/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2661	Rev E								

100
100
 HAAS 1
 HAAS CNC vertical machine #1
 HAAS CNC VERTICAL MACHINING #1
 Memo
 Program part number and batch number.
 Program part number and batch number
 MACHINE AS PER DWG AND FOLIO FB073
 FOLIO REV: AA
 DWG REV: E
 0.00
 0.00
 10

110
110
 Mill Conv
 Conventional Milling Machine
 CONVENTIONAL MILLING MACHINE
 Memo
 Machine Keyway and inspect per attached dimension sheet
 0.00
 0.00
 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79199

January-23-12 1:58:14 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 23/01/2012 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 06/02/2012 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC Memo

0.00

Quality Control

130 QC8- Inspect parts - second check

0.00

130

QC Memo

0.00

Quality Control

140 Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish Memo

0.00

Hand Finishing

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:50								
	FINISH TIME: 10:20								
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 424	0.00							
170									
Packaging	Memo	0.00							
Packaging									

10x4 M. 12/03/02

W120222

10 Bl 12-3-2

424/3/2 (10)

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 12/03/05

12-03-5
(10)

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Picklist Print

Page 1

January-23-12 1:58:18 PM

Work Order ID: 79199

79199

Parent Item: D2661-1

D2661-1

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	80.0000	1	10			
D6101-003									**			<u>A.A 12/02/21</u>	
Saddle Billet, 7075													

Location

Loc Qty

Loc Code

MAT040

86

73775

2

73780

7

77562

10

78599

60

MAT042

-7

MAT044

1

73769

1

→ 79587

10.0

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DART AEROSPACE LTD		Work Order:	79199
Description: 206 Saddle, Outboard, Left side		Part Number:	D2661-1
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.260	.260	.260	.260	.260
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.124	.124	.124	.124	.122
H	0.210	0.230		.227	.227	.228	.227	.225
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.327	1.328	1.327	1.327	1.323
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.134	1.135	1.134	1.1335	1.133
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140		.131	.131	.131	.131	.130
Q	0.240	0.260		.251	.255	.253	.253	.252
R	0.677	0.697		.686	.687	.687	.687	.687
S	0.100	0.140		.118	.120	.120	.120	.120
T	1.565	1.585		1.575	1.5755	1.575	1.574	1.574
U	0.540	0.560		.552	.550	.550	.550	.550
V	0.912	0.932		.922	.922	.922	.922	.922
W	0.787	0.807		.797	.797	.797	.797	.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.497	.500	.499	.500	.498
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.500	.500	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.236	.235	.236	.236	.236
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.109	.108	.109	.109	.109
AI								

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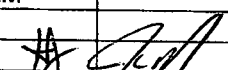
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DART AEROSPACE LTD		Work Order:	79199
Description: 206 Saddle, Outboard, Left side		Part Number:	D2661-1
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: FK	Date: 12/02/23
Audited by: JL	Date: 12-02-24
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

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FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6 X	7 A	8 A	9 A	10 A
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.260	.260	.260	.260	.260
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	.100	0.140		.120	.120	.120	.119	.119
H	0.210	0.230		.225	.225	.225	.225	.225
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.496	2.496	2.496	2.496	2.496
K	1.313	1.343		1.323	1.325	1.323	1.323	1.323
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.1335	1.134	1.1335	1.134	1.134
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140		.130	.130	.130	.130	.130
Q	0.240	0.260		.250	.250	.250	.250	.251
R	0.677	0.697		.687	.687	.687	.687	.687
S	0.100	0.140		.121	.120	.120	.120	.120
T	1.565	1.585		1.574	1.575	1.574	1.575	1.574
U	0.540	0.560		.550	.550	.550	.550	.550
V	0.912	0.932		.922	.922	.922	.922	.922
W	0.787	0.807		.797	.797	.797	.797	.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.499	.499	.498	.499	.500
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.500	.500	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.236	.236	.236	.235	.235
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.109	.109	.109	.108	.108
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Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

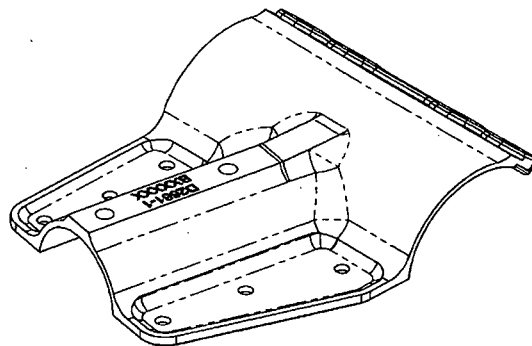
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: F.K. **Date:** 12/02/24

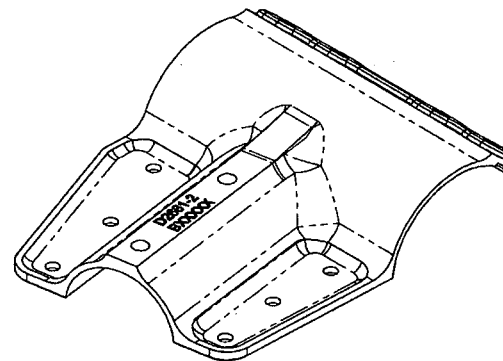
Audited by: SL **Date:** 12-02-24

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
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G	11.11.07	Dimensions C and F revised	KJ	
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D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

RELEASED
2011-11-16

SHOWN
RETURN
ENGINE
UNCONTROLLED
SUBJECT TO CHANGE

WITHOUT NOTICE
WORK ORDER

NO 79195 MLJ
12/01/23

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B8-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	07.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	GP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	GP		
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	LM	D2661	SHEET 1 OF 5
APPROVED	LM	TITLE	SCALE
DE APPR.	LM	SADDLE, OUTSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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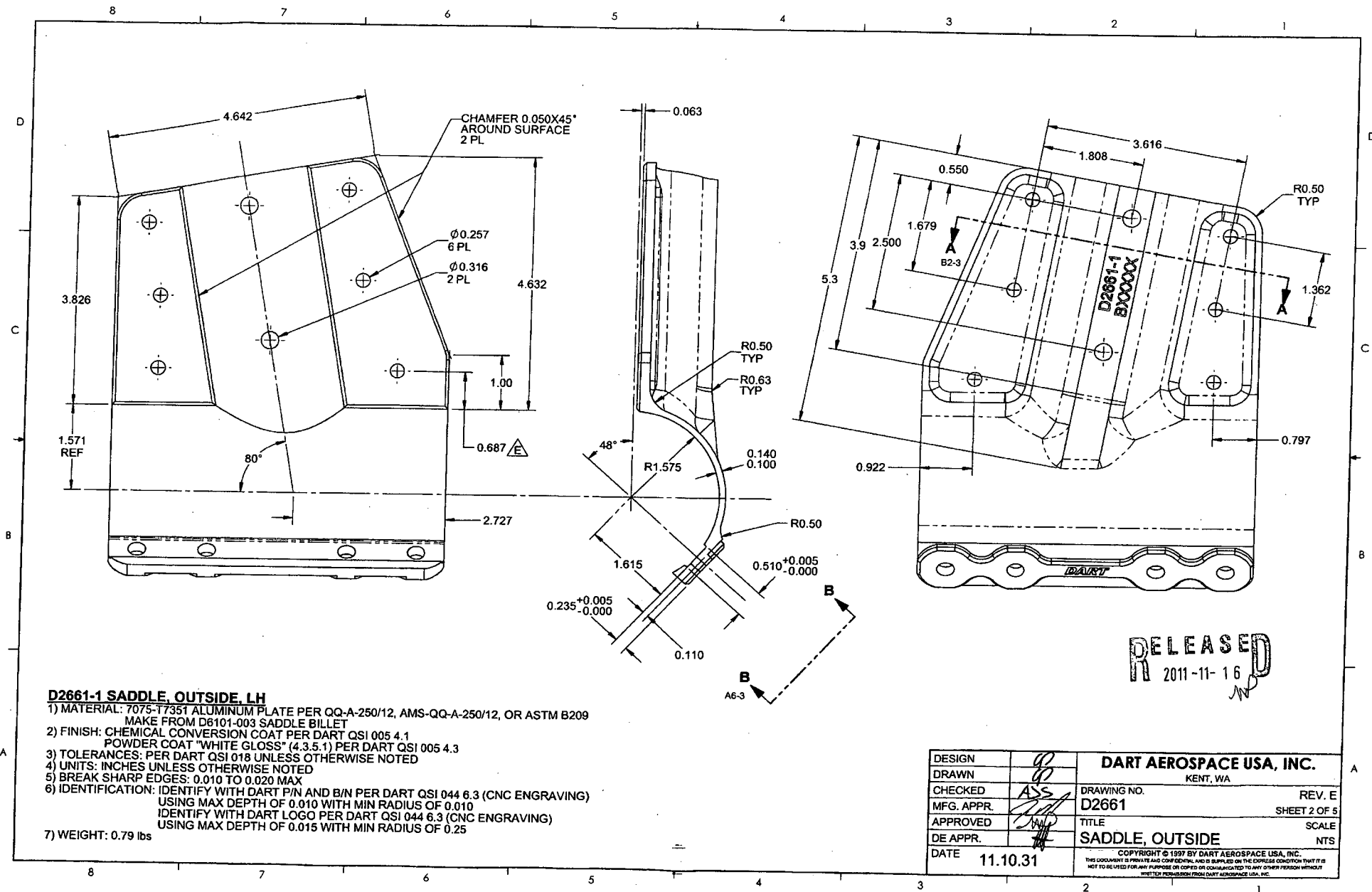
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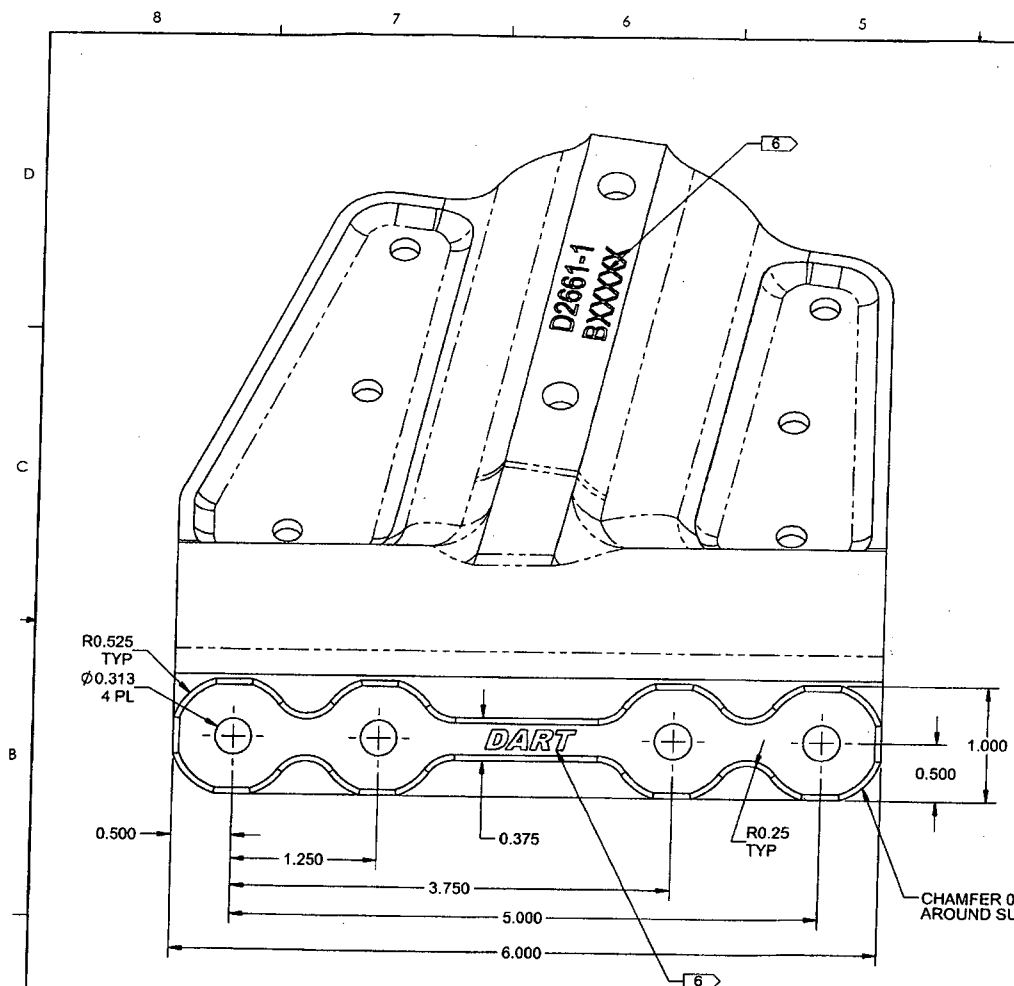
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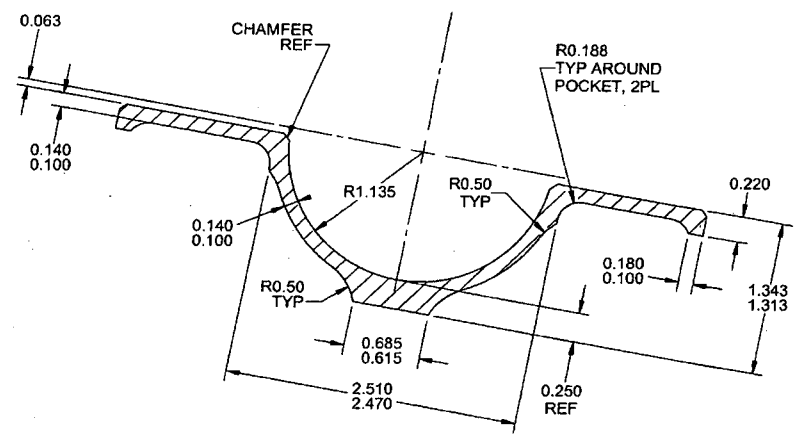
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NOTE: Date & initial all entries

79195



VIEW B-B
SCALE 1.5X
VIEW ROTATED
A4-2



VIEW A-A
SCALE 1.5X
C3-2

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	JP	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	JLD	D2661	SHEET 3 OF 5
APPROVED	JLD	TITLE	SCALE
DE APPR.	#	SADDLE, OUTSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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D2661-2 SADDLE, OUTSIDE, RH

1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25

7) WEIGHT: 0.79 lbs

RELEASED
2011-11-16

DESIGN	ASS	DART AEROSPACE USA, INC. KENT, WA
DRAWN	ASS	
CHECKED	ASS	DRAWING NO. D2661
MFG. APPR.	ASS	REV. E SHEET 4 OF 5
APPROVED	ASS	TITLE SADDLE, OUTSIDE
DE APPR.	ASS	SCALE NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

RELEASED
2011-11-16

D2661-2 SADDLE, OUTSIDE, RH

- DRAWING SADDLE OUTSIDE, RA**
- 1) MATERIAL: 7075-T351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN	<i>B</i>	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D2661 TITLE SADDLE, OUTSIDE COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRINTED AND COPYABLE UNDER THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	REV. #
DRAWN			SHEET 4 OF 4
CHECKED	<i>ASS</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.10.31		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

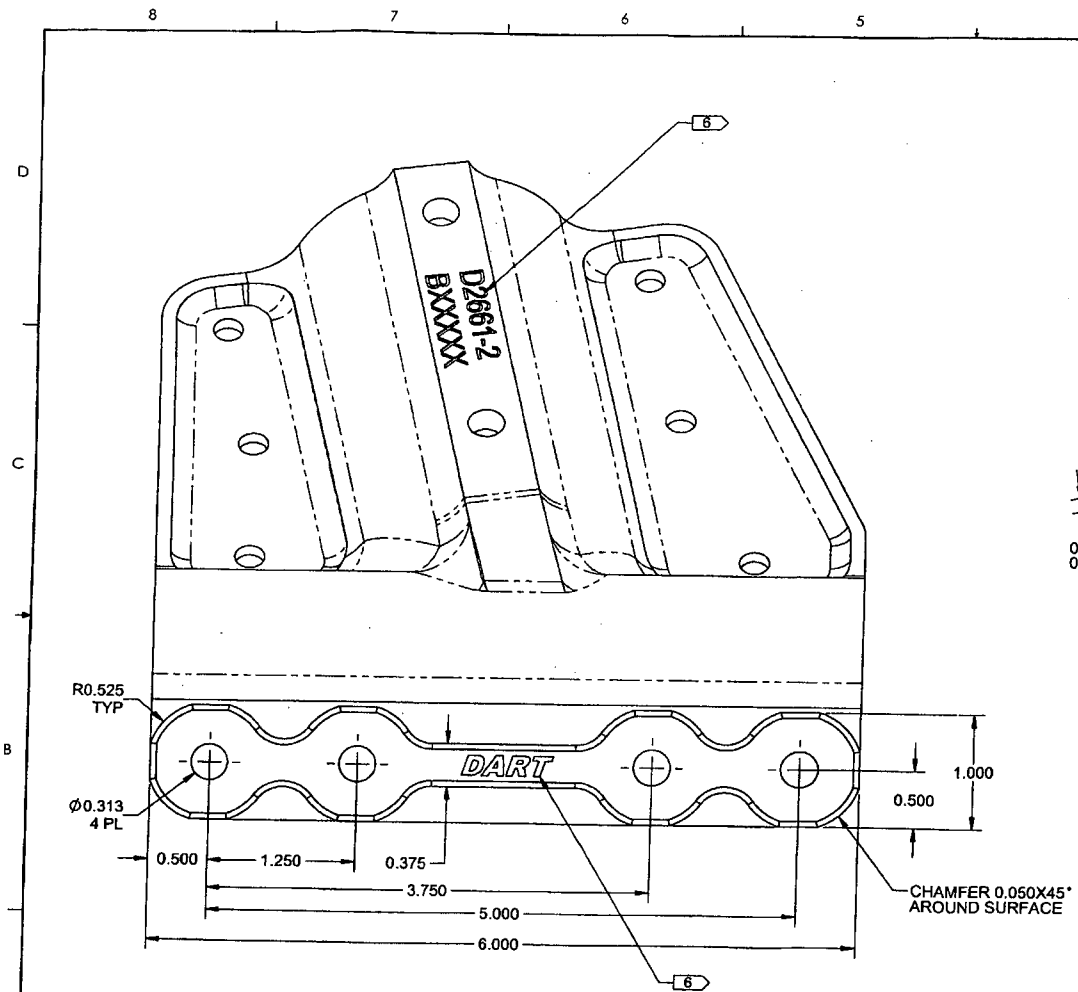
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

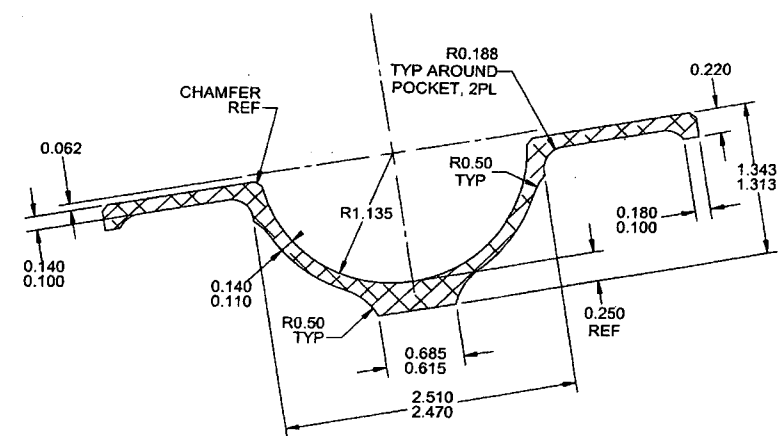
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

72199



VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



SECTION C-C C1-4
SCALE 1.5X

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED	ASS	DRAWING NO. D2661	REV. E
MFG. APPR.			SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries